

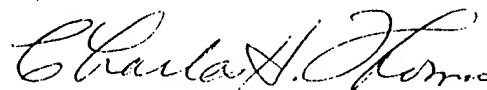
REMARKS

Applicant has amended Claims 2, 3, 6, 7, and 8 as suggested by the Examiner in paragraph 2 of the Official Action. The revised claims have been printed above in a clean form and a comparison copy of the prior version of these claims in the form in which they were amended in the Amendment filed on June 12, 2000 is attached hereto as Appendix A, as provided by revised Rule 121 of the Rules of Patent Office Practice. It is believed that with the revision of Claims 2, 3, 6, 7, and 8, as indicated above, that the rejection of Claims 2 through 8 under 35 U.S.C. § 112 in the last Official Action is no longer warranted.

In the last Official Action the Examiner also rejected all of the claims under 35 U.S.C. § 103 on essentially the same basis as in the earlier Official Action, and made the rejection final. Accordingly, Applicant has filed a Notice of Appeal of the rejection of these claims, a courtesy copy of which is enclosed herewith.

Date: November 28, 2000

Respectfully submitted,



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2. (Twice Amended) A method according to Claim 1 including a plurality of transverse security bars ~~{extending between and into said stile members}~~ and a plurality of upright security bars ~~{extending between and into said rail members}~~ and a plurality of upright security bars, and further comprising forming said stile members and said ~~{transverse}~~ rail members with flat, inwardly directed attachment flanges ~~{across which said security bars pass}~~, positioning said transverse security bars so that they pass across said attachment flanges of said stile members, and positioning said upright security bars so that they pass across said attachment flanges of said rail members wherein said upright and transverse security bars reside in contact with and are spot welded to said attachment flanges across which they pass.

3. (Twice Amended) A method according to Claim 2 further comprising forming and positioning said attachment flanges in mutually coplanar relationship with each other to reside in a common plane and said step of spot welding is performed to attach said transverse security bars ~~{that extend into and between said stile members}~~ to said attachment flanges of said stiles ~~{thereof}~~ members on one side of said common plane and said step of spot welding is performed to attach said upright security bars ~~{that extend between and into said transverse rail members}~~ to said attachment flanges of said rail members ~~{thereof}~~ on the opposite side of said common plane.

6. (Twice Amended) A method according to Claim 5 further comprising initially cutting spot welding tip access apertures in said ~~single~~, flat, sheet metal strip, thereby creating at least one spot welding tip access aperture in said hollow members at each of said corners, and spot welding said pairs of corner securing tabs to ~~{said other of}~~ said adjacent hollow members ~~{adjacent thereto}~~ by inserting internal spot welding tips into said spot welding tip

access apertures so as to contact said corner securing tabs within said adjacent hollow members, bringing external spot welding tips into external contact with said adjacent hollow members and passing electric currents between said internal and said external spot welding tips to spot weld said hollow members together at each of said corners.

7. (Twice Amended) A method of fabricating a metal security door comprising:

forming four hollow metal door perimeter segment members so as to define a plurality of security bar receiving openings in each of said perimeter segment members,

5 positioning a plurality of metal security bars to project through said security bar receiving openings and into said hollow-perimeter segment members so that said ends of said metal security bars terminate within said perimeter segment members and positioning said perimeter segment members together to form a rectangle, and spot welding said ends of said metal security bars to said perimeter segment members within which they terminate.

8. (Twice Amended) A method according to Claim 7 further comprising roll

forming said hollow segment members so as to create a security bar attachment flange on each of said hollow perimeter segment members, whereby when said perimeter segment members are positioned together to form said rectangle said attachment flanges all project inwardly within said rectangle and lie in a common plane, and whereby said security bar receiving openings in each of said perimeter segment members reside proximate to said security bar attachment flange thereof on one side of said common plane while said security bar receiving openings in each adjacent perimeter segment member lie on the opposite side of said common

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plane.